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C3-7-2

Job Sheet 184713



Part No: C3-7-2

Job Qty: 20 ea

Part Name: Lock Bumper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C3-7-2 Rev A IPP Rev A 18.04.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	20 pcs	11/9/18	11/9/18	0.00	20.00	Small Fab-3		HODAS AP
120	QC	20 pcs	11/9/18	11/9/18	0.00	0.00	QC5		38
130	Packaging	20 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		DAS 9-88
140	QC21-SA	20 Ea	11/9/18	11/9/18	0.00	0.00	QC21		21 DEC 10 2018

Part Op 110 - 1-Mix 80A liquid urethane using base and activator as per manufacturer instructions. A/R; M 8644K12
Descriptions: EXP. 3/19 2-Pour into appropriate mold. 3-Let cure as per manufacturer instructions. Time; 10:30 Date; 19 Oct 2018 4-Remove from mold. 5-Chamfer ends as per DWG. 6-Deburr if required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
8644K12	80A Liquid Urethane	.0200 pcs (.001 ea)	90-Start up Operation	5098723

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	8644K12	0	3	0

Part Specifications

Specifications could not be found.



Container No: S120071



Part: C3-7-2

Job No: 184713

Serial No/Batch: S120071

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 10/22/18

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Plex 10/16/18 10:59 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
NCR No. _____		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Large Fab ☐	Composite ☐	Supplier ☐			

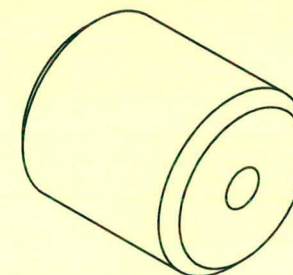
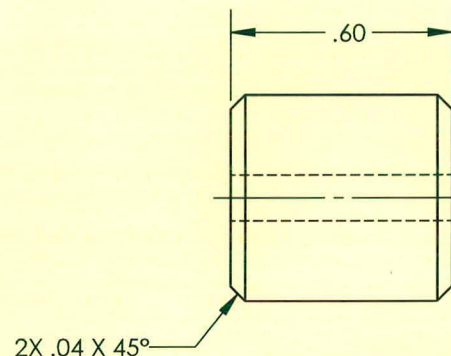
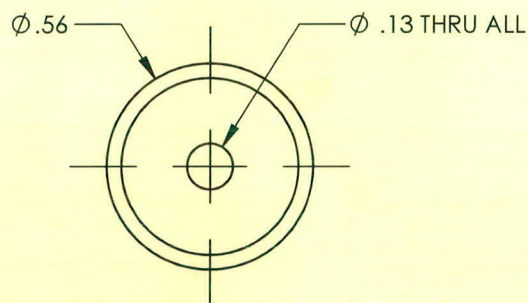
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE. CH'D DIMENSION TOLERANCE WAS $\varnothing .563$ IS $\varnothing .56$, WAS $\varnothing .125$ THRU ALL IS $\varnothing .13$ THRU ALL, WAS $.600$ IS $.60$.	8/7/2014	DJN
				RW



SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184713 MJD
187076

NOTE:
BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK BUMPER C3-HOOK	
DWG NO. C3-7-2	REV A
MAT'L POLYURETHANE	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED <i>D. Weid</i>	
HEAT TREAT	
FINISH	
SPEC	
USED ON MODEL	
SCALE 2:1	DATE 11/18/2001
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C3-7-2	1	LOCK BUMPER	POLYURETHANE	POLYURETHANE	

